

Date: Thursday, 2/14/2008 11:01:33 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: PANEL		
Job Number	: 37442					
Estimate Number	: 10906					
P.O. Number	:		Part Number	: D33303		
This Issue	: 2/14/2008	S.O. No. :	Drawing Number	: D3330 REV D		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: / /	Type : SMALL /MED FAB	Drawing Revision	: D		
Previous Run	: 35487		Material	:		
Written By	:	<i>[Signature]</i>	Due Date	: 3/15/2008	Qty:	6 Um: Each
Checked & Approved By	:	<i>[Signature]</i>				
Comment	: Est. A 05.01.13 New issue KJ/JLM Est Rev:B Now on Waterjet 06-09-25 JLM est C 07.05.14 rev C dwg ec Est D 07.12.12 Rev D dwg EC veryfie by:DD					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M1010S125	1010-1025 sheet .125	
		Comment: Qty.: 0.7130 sf(s)/Unit Total : 4.2777 sf(s) 1010-1025 sheet .125 Batch: <i>166140 B 8-2-22</i>	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3330 Dwg Rev: <i>C</i> <i>B 8-2-22</i> Prog Rev: <i>C</i> <i>(6)</i>	
		2-Deburr if necessary <i>B 8-2-22</i>	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		<i>B 8-2-22</i>	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		<i>J 0802-25 (6)</i>	
		Comment: SECOND CHECK	
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
		<i>ST 488 AS 08/03/11 (XG)</i>	
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 08/03/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/14/2008 11:01:33 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL

Job Number: 37442

Part Number: D33303

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



(6)

Comment: FINAL INSPECTION/W/O RELEASE

Do 08/03/12

Job Completion



in 2008/3/12

(6)

W/I/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37442
Description: Plate	Part Number:	D3330-3
Inspection Dwg: D3330	Rev: <i>E</i> D	08.12.14

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>HB</u>	Audited by:	<u>/</u>	Prototype Approval:	N/A
Date:	<u>8-2-25</u>	Date:	<u>6802-25</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.16	New Issue	KJ/JLM	E

DARTDESIGN *B*DRAWN BY *DC***DART AEROSPACE LTD**

HAWKESBURY, ONTARIO, CANADA

CHECKED *B*APPROVED *M*

DRAWING NO.

D3330

REV. D

SHEET 1 OF 9

DATE

07.12.06

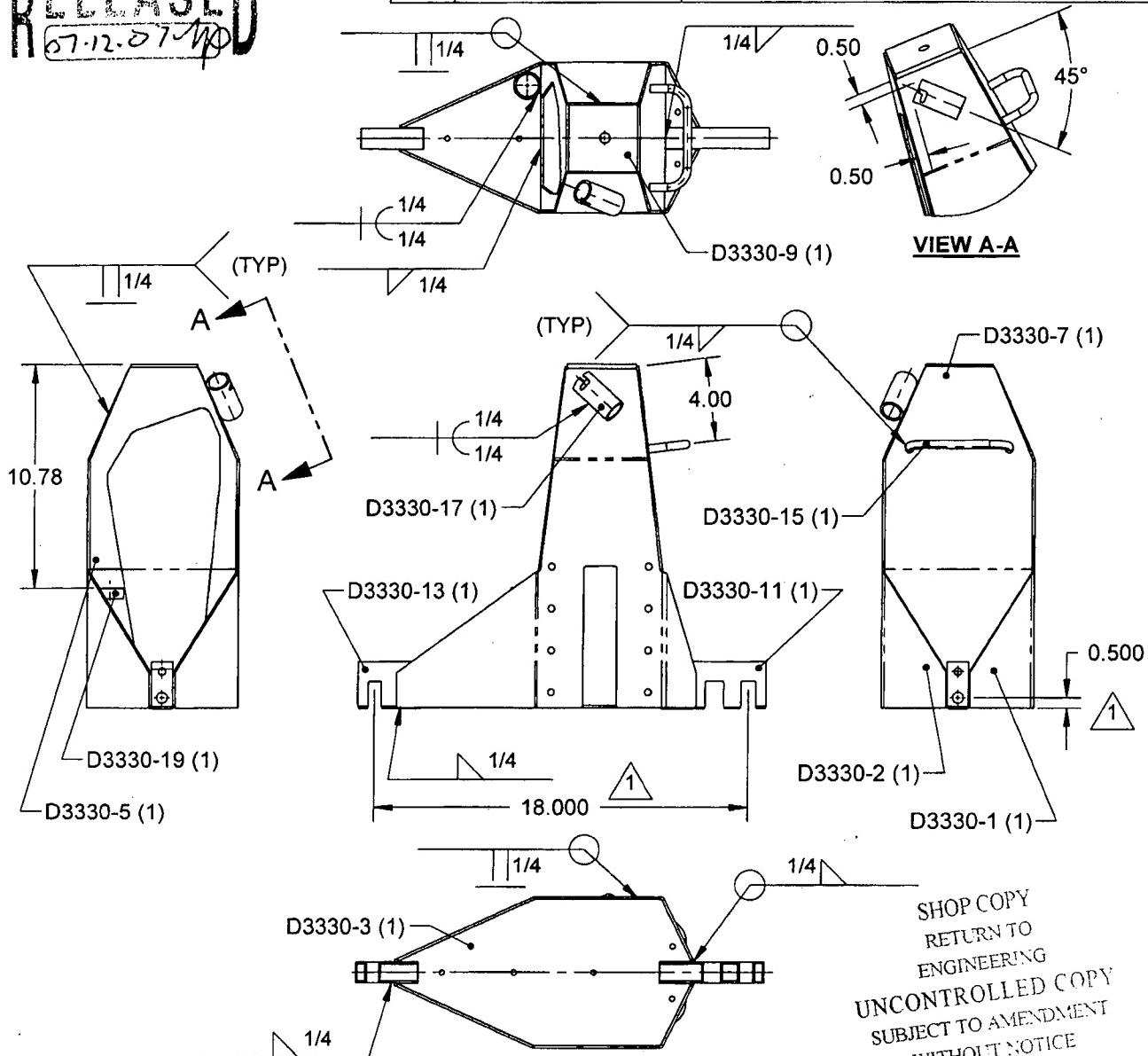
TITLE

FRAME WELDMENT

SCALE

1:8

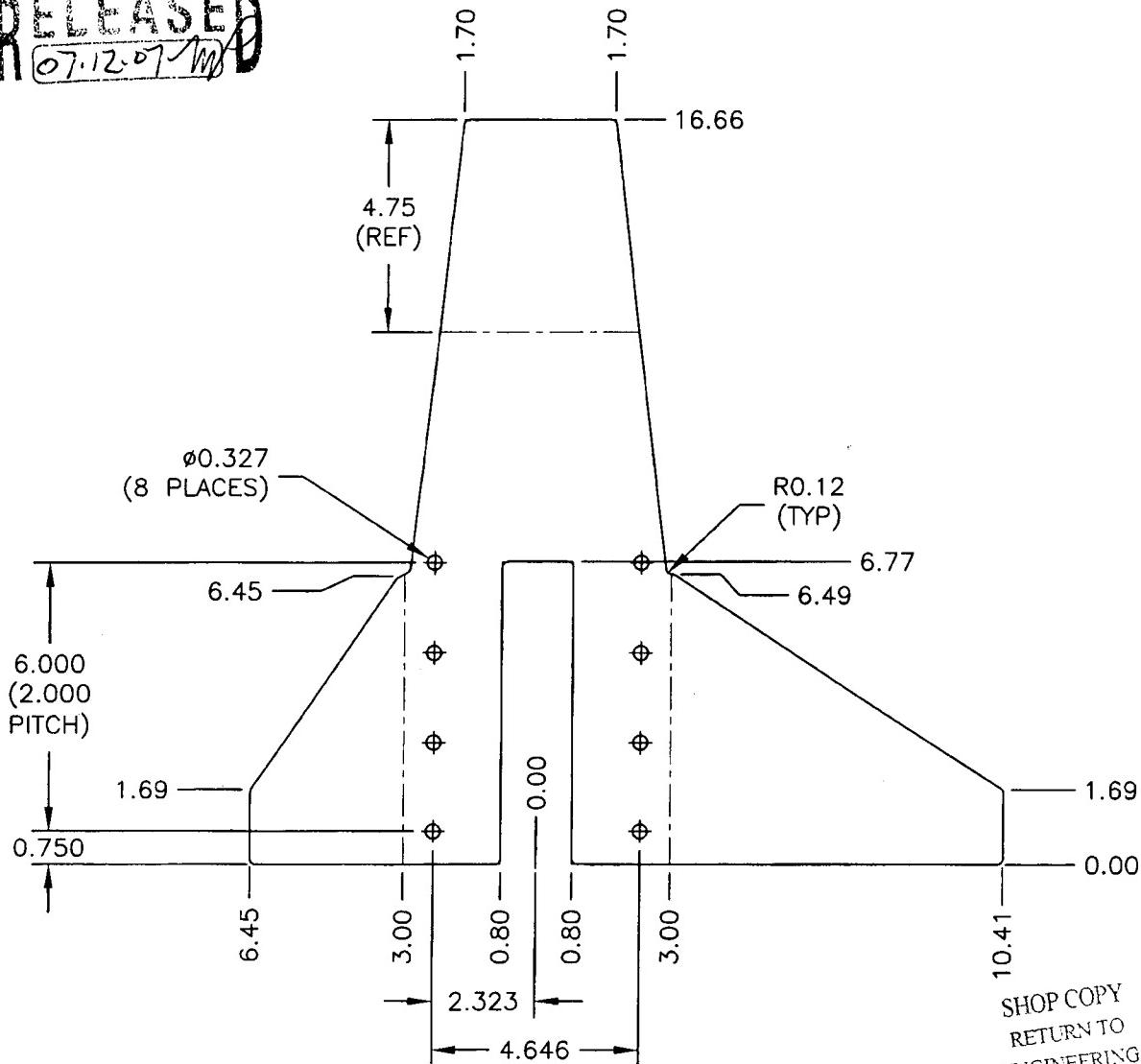
REV	DATE	DESCRIPTION
A	04.12.16	NEW ISSUE
B	05.02.26	RE-DESIGN
C	07.03.20	ADD 0.100 DIM; RAISED BEND OF -1/2 BY 0.125
D	07.12.06	CHANGE DIMS ON D3330-9

RELEASED
07.12.07 *mpd***D3330-041 FRAME WELDMENT****NOTES:**

- 1) POSITION PARTS AS PER JIG D3330-041T1
- 2) WELD PER QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

DART

DESIGN <i>B</i>	DRAWN BY <i>DC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>J</i>	APPROVED <i>M</i>	DRAWING NO. D3330	REV. D SHEET 2 OF 9
DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:4

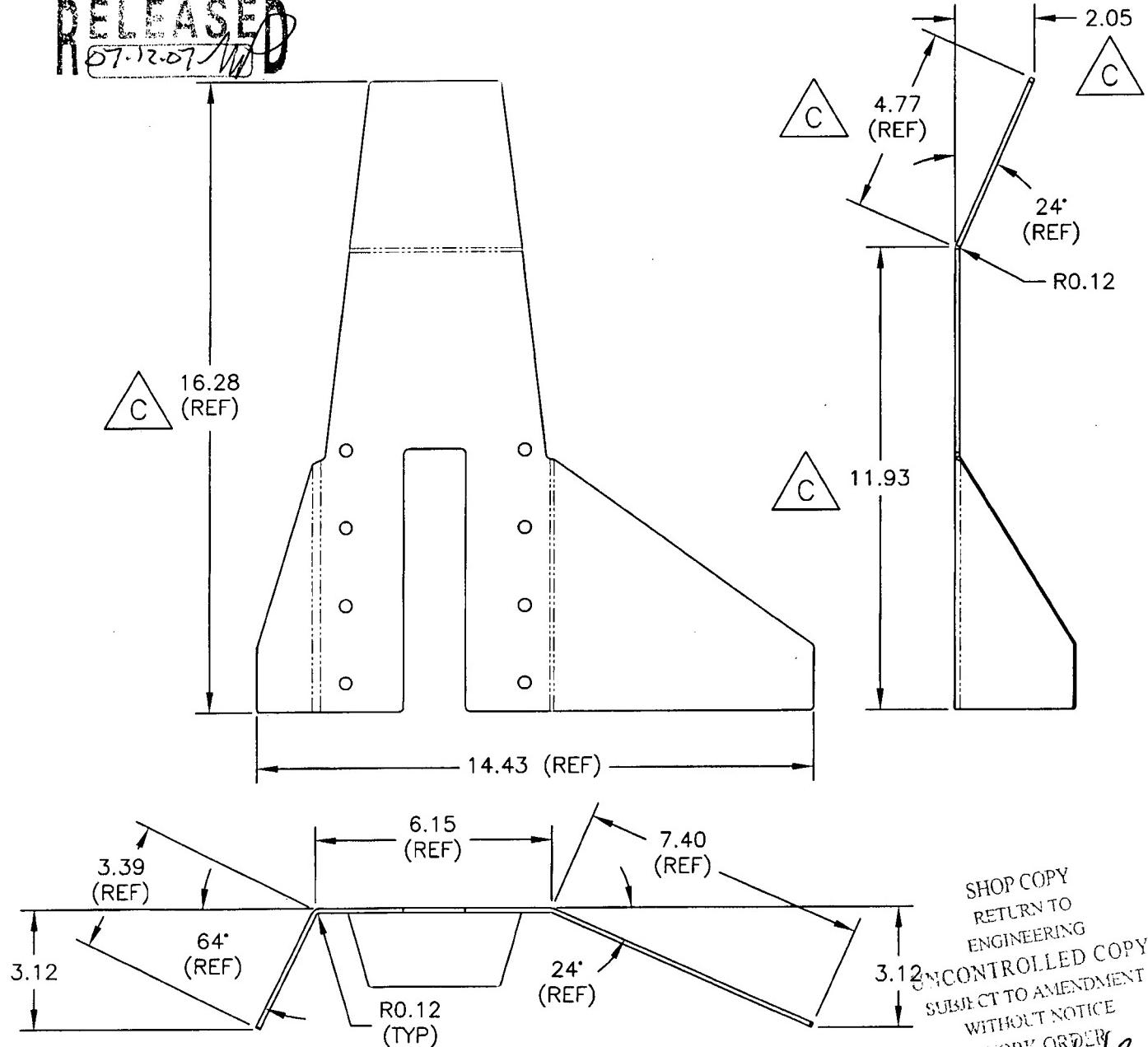
RELEASED
07.12.07 *WJD***D3330-1 PANEL****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,
38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NO. *37442*

DART

DESIGN HB	DRAWN BY <i>SC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED <i>NP</i>	DRAWING NO. D3330	REV. D SHEET 3 OF 9
DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:4

RELEASED
07.12.07

D3330-1 BEND DETAIL (SHOWN)
BEND D3330-2 (OPPOSITE)

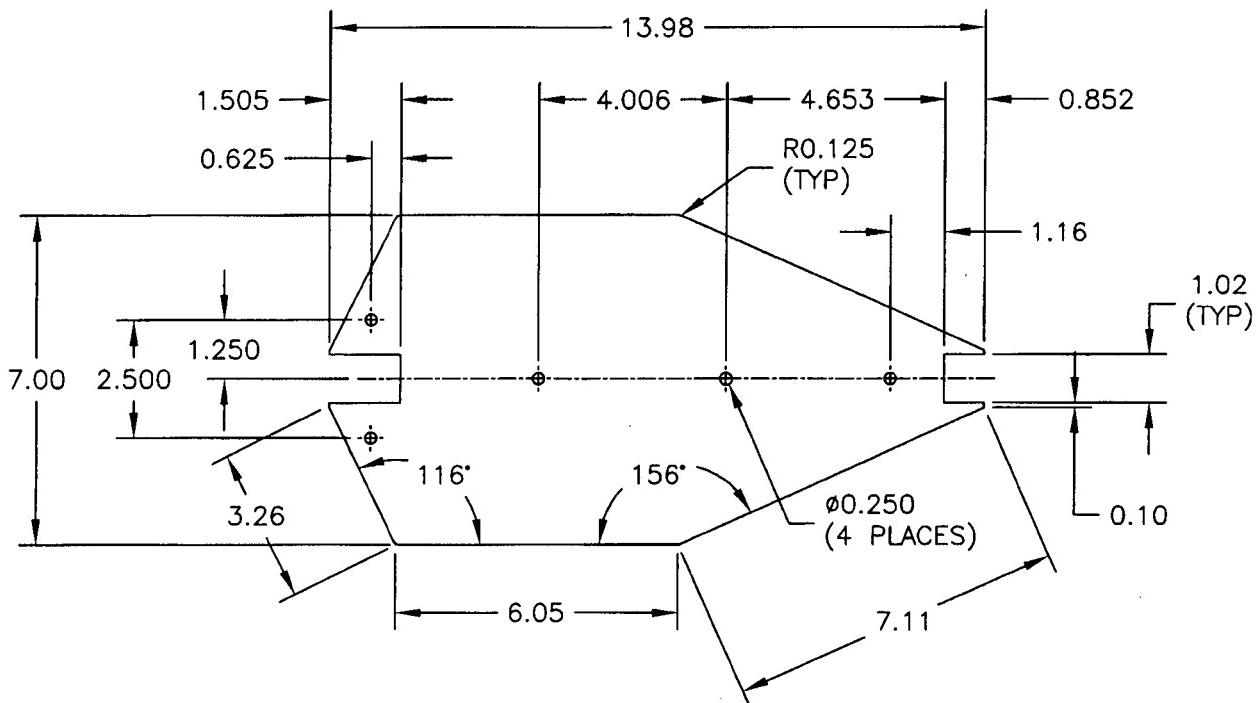
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CHECKED B	APPROVED MP	DRAWING NO. D3330
DATE 07.12.06		REV. D SHEET 4 OF 9 TITLE FRAME WELDMENT SCALE 1:4

RELEASED
07.12.07 MP

**D3330-3 PLATE**

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NOTES:

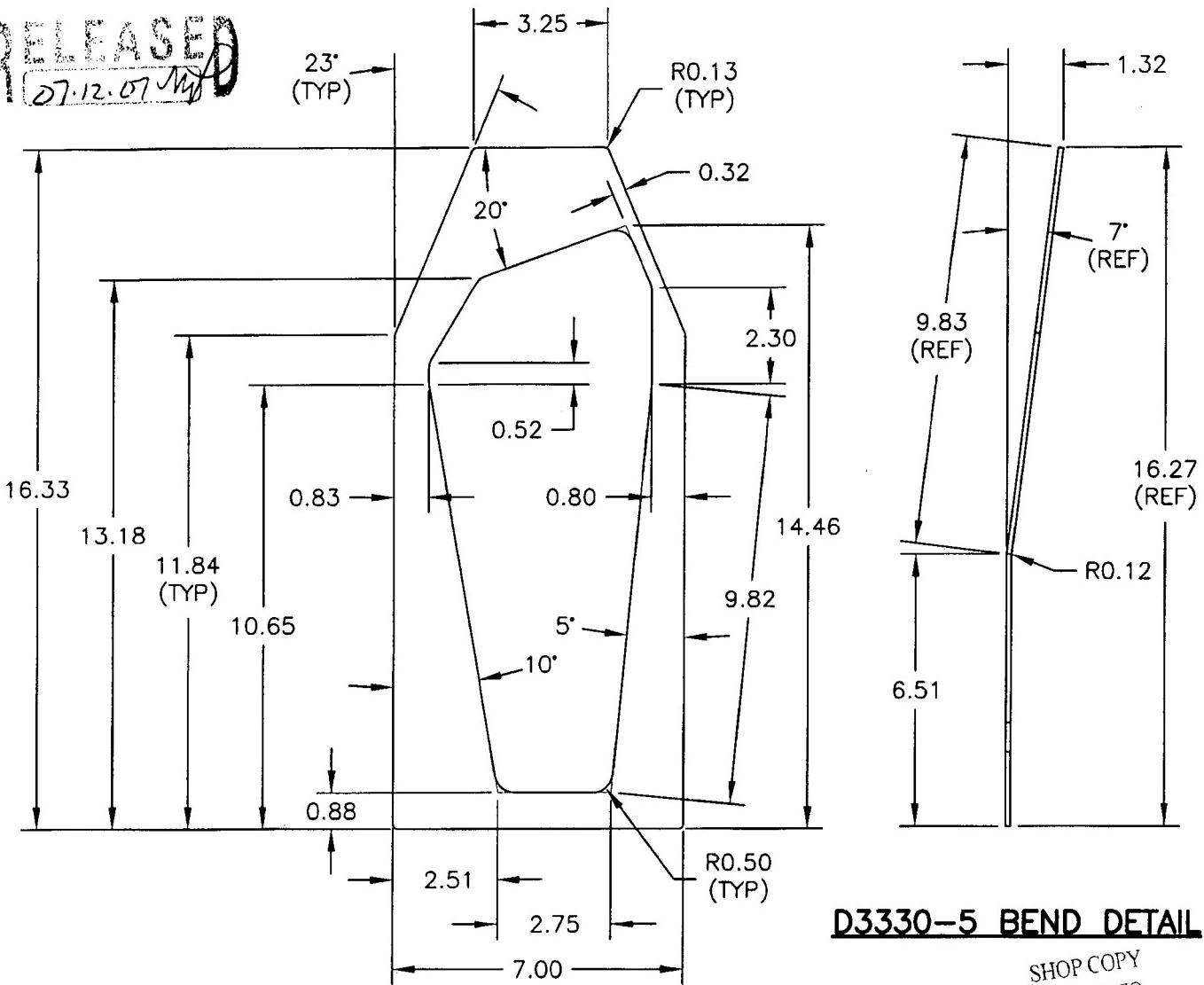
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,
38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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CHECKED <i>LS</i>	APPROVED <i>MW</i>	DRAWING NO. D3330	REV. D SHEET 5 OF 9
DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:4

RELEASED
(07.12.07) *MWD***D3330-5 BEND DETAIL**

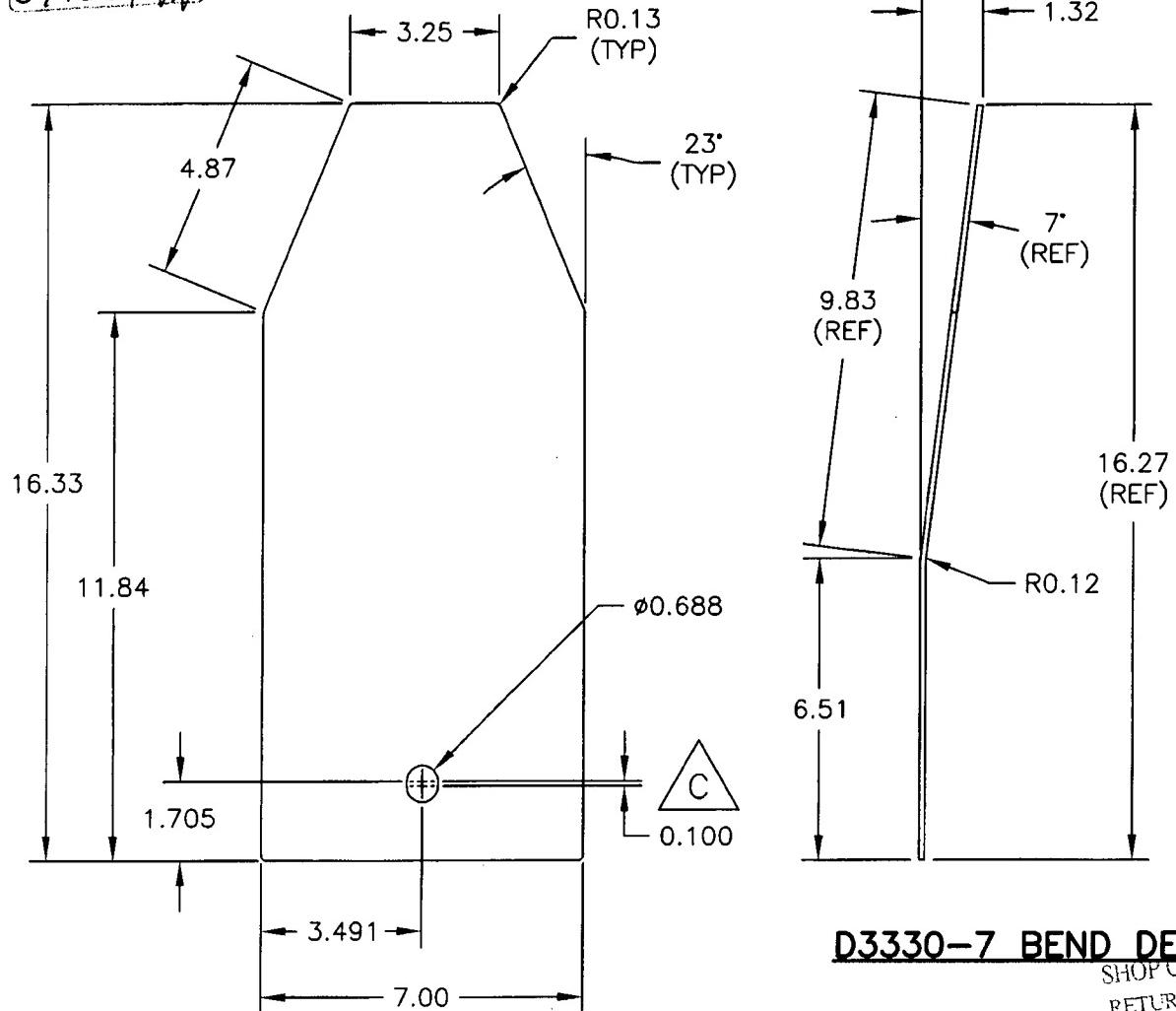
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NO. *37442*

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,
38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

DART

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DATE 07.12.06		TITLE FRAME ASSEMBLY

REV. D
SHEET 6 OF 9
SCALE
1:4**RELEASED**
07/12/07 MB**D3330-7 BEND DETAIL**

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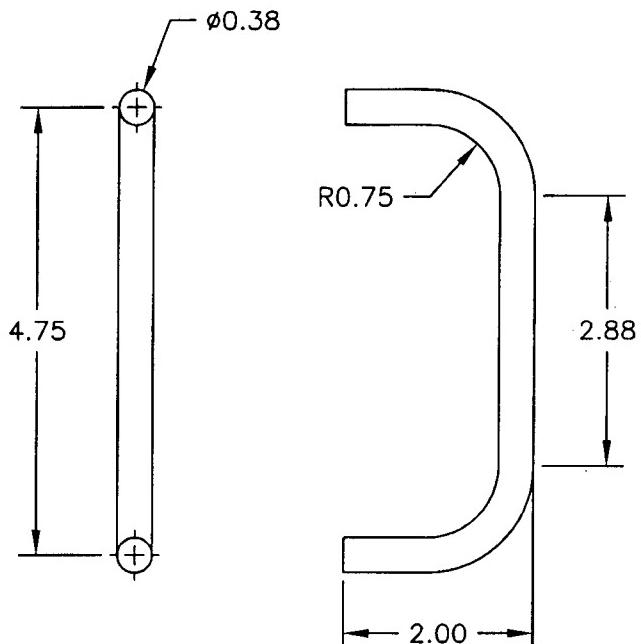
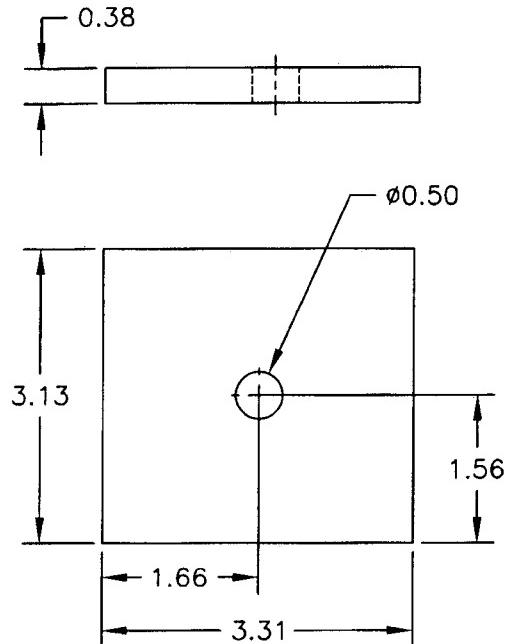
NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,
38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

DART

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CHECKED <i>BS</i>	APPROVED <i>M</i>	DRAWING NO. D3330	REV. D SHEET 7 OF 9
DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:2

RELEASED
07.12.07 *WHD*



△ D3330-9 TOP PLATE

△ D3330-15 HANDLE

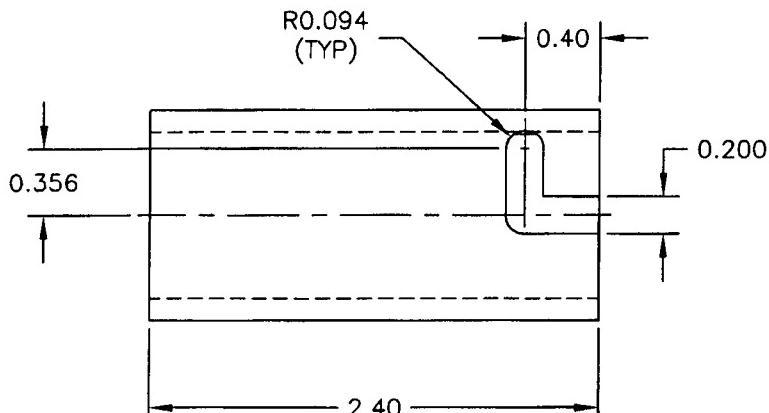
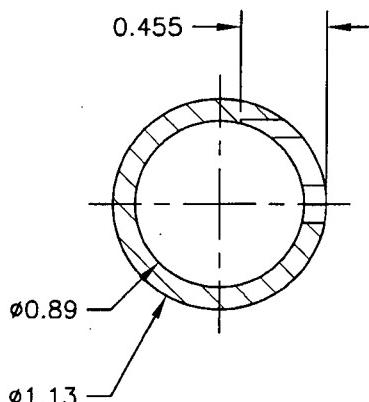
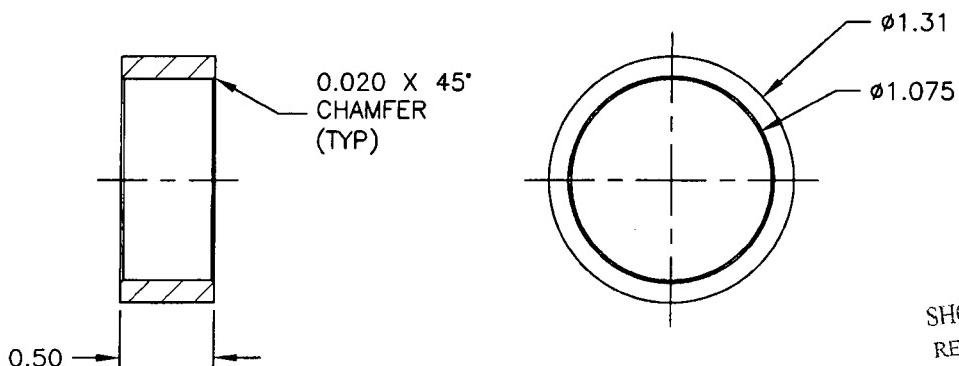
NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008, 0.375 STEEL
(REF. DART SPEC. M1010-B0.375x3.500)
- 2) MATERIAL: AISI 1018-1025 ROUND BAR PER MIL-S-7097
(REF. DART SPEC. M1018-R0.375)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:1

**RELEASED**
(07.12.07) MPSECTION A-AD3330-17 HANDLE SOCKETD3330-19 HANDLE RIM

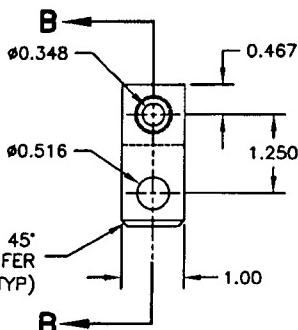
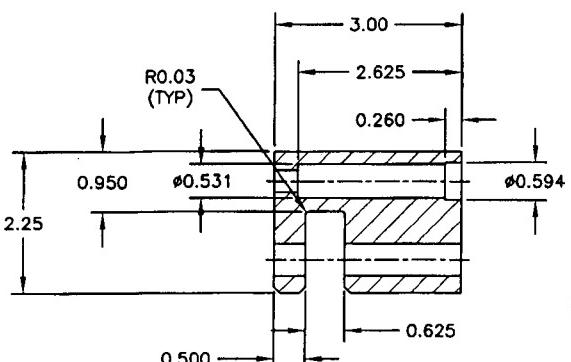
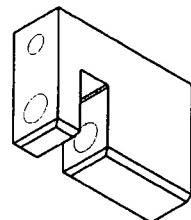
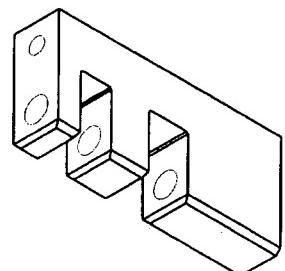
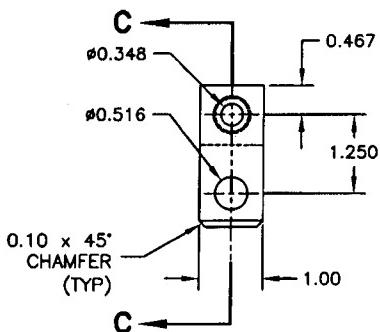
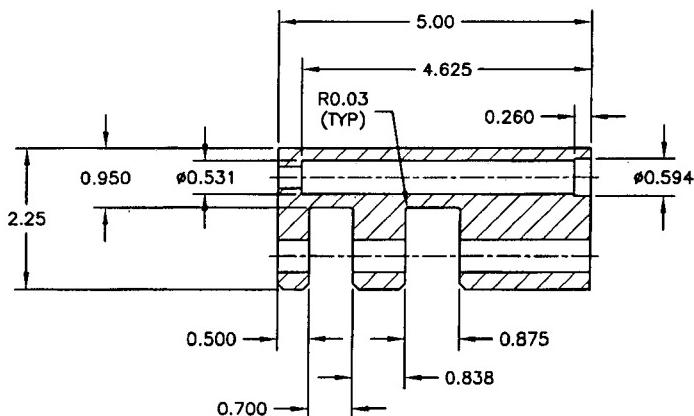
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NOTES:

- 1) MATERIAL: 1010-1025 ROUND BAR STEEL PER MILL-S-7097
(REF. DART SPEC. M1025TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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CHECKED	APPROVED <i>MW</i>	DRAWING NO. D3330
DATE	07.12.06	REV. D SHEET 9 OF 9 TITLE FRAME WELDMENT SCALE 1:3

**RELEASED**
07.12.07 MW**SECTION B-B****D3330-13 SHORT PIN BRACKET****SECTION C-C****D3330-11 LONG PIN BRACKET****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.000 THICK STEEL
(REF. DART SPEC. M1010-B1.000x02.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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